

Date: Friday, 20/06/2008 10:39:15 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEB		
Job Number	: 39983			Part Number	: D2739		
Estimate Number	: 10498			Drawing Number	: D2739 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 20/06/2008 S.O. No. :			Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SKIDTUBES			Due Date	: 30/06/2008 Qty: 4 Um: Each.		
Previous Run	: 39915						
Written By	:						
Checked & Approved By	: JUL 08-10.20						
Comment	: Est Rev: C 02.11.28 Rerformat KJ Est Rev: D 06-03-21 As Per Rev C JLM Est Rev: E 07-07-28 As per Rev D JLM Verified By:						

Additional Product

Job Number:	
Seq. #:	Machine Or Operation:
1.0	D26005108 
	Description : Extrusion 'I Beam' thin
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	
Extrusion 'I Beam' thin	
Pick:	
Qty Part Number Description Batch	
1 D2600-5 Web B - 29985 AWM 8-6-23	
2.0 SKIDTUBES 1 	SKIDTUBES RESOURCE 1 
Comment: LANDING GEAR RESOURCE 1	
1-Cut D2600-5 to length as per Dwg D2739.	
2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739	
3-Use uni-bit to open holes to finish size as per Dwg D2739.	
4-Bevel Fwd end of extrusion and Deburr holes and ends.	
5-Dburr	
3.0 QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEB

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Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Awm



8-6-23

4

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1 8-6-23

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location: L-6

Awm 8-6-23

4

7.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

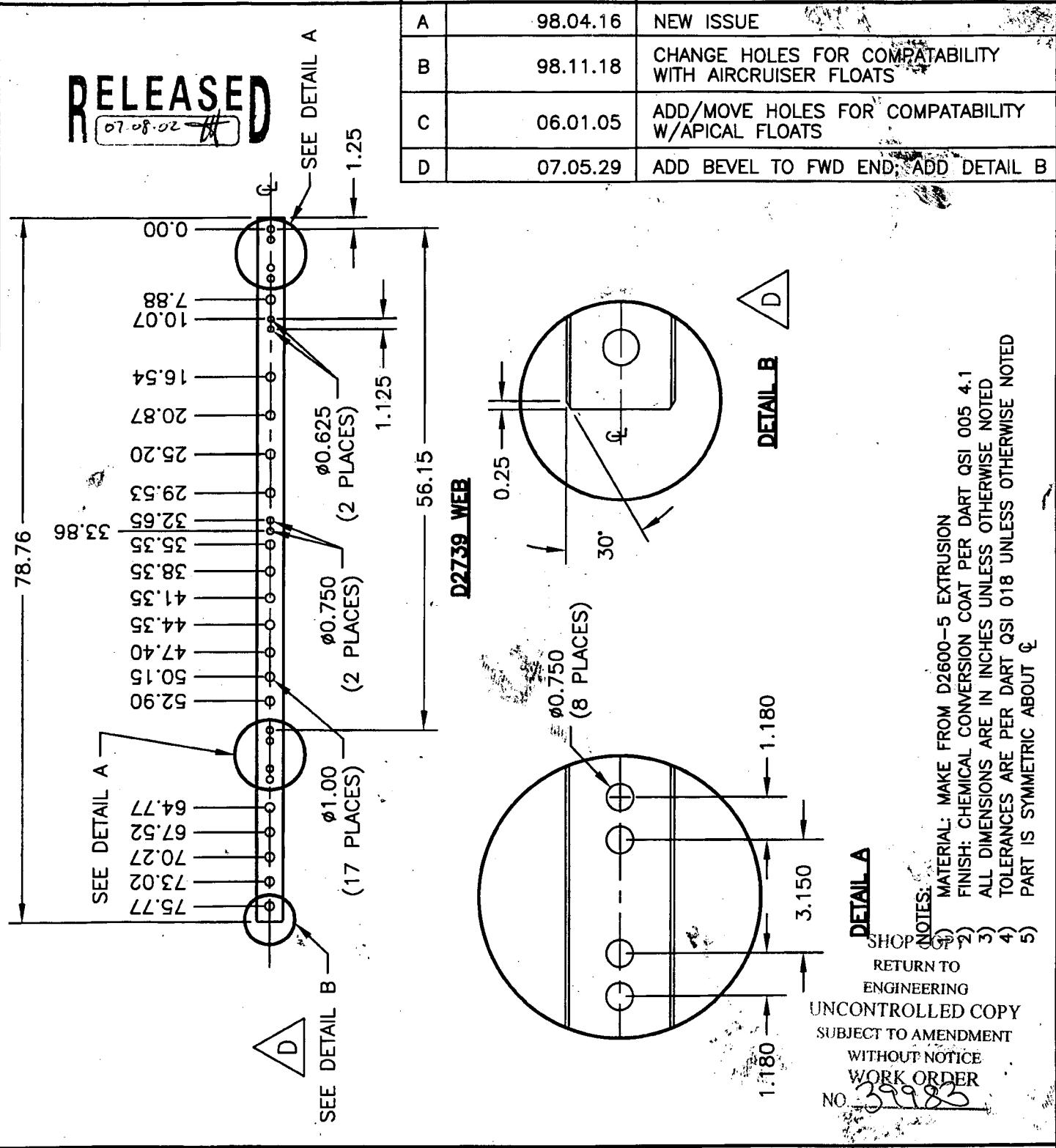
NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2739
DATE 07.05.29		REV. D SHEET 1 OF 1
		TITLE WEB
		SCALE 1:15

RELEASED

20-80-70



NOTES:
 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) PART IS SYMMETRIC ABOUT \perp

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 NO. 39985

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